

628-022 Blue

Dart Aerospace Ltd.

Date: Thursday, 05/02/2009 3:44:50 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206L/407 STEP ASSY, RH		
Job Number	: 45547A			Part Number	: D2724042 BL		
Estimate Number	: 11703			Drawing Number	: D2724 REV C		
P.O. Number	:			Project Number	:		
This Issue	: 05/02/2009 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 10/03/2009 Qty: 2 Um: Each		
Previous Run	: 39838A						
Written By	:						
Checked & Approved By	: JLM 09-02-09						
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
✓ 1.0	D2622120C	Step Extrusion	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>46910</u>			
Check Material for any Dents or Defects			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment: LARGE FABRICATION RESOURCE 1 Cut D2724-2 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding			
3.0	D2734	Step End Plate	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>343535</u>			
4.0	D34581	Step Mounting Plate	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3458-1 Plate <u>344002</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 45547A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34583 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D34583	Plate	344003

H 09.06.10 2

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig
DT (One End Only)

A/R AL ROD Batch: *M11C13C*
M11C0972

BK 09.06.10 2

Grind end cap welds flush

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.11 (2)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/11 (2) R17

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(2) R17

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BK 09.06.12

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09 - 06 - 12 (2) R17

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

H 09.06.12 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:50 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 45547A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M110130

M 09-06-12

2

Grind end plate flush.

M 09-06-12

2

12.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

P 09-06-15

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09-06-15 X 2RH

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

X2

Touch up Alodine

UMD 09/06/15

15.0 SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B 110199

-SPRAY PAINT DELFLEET BLUE

B 110077

-CLEAR DELFLEET

B 110899

M 09-06-15 Q

16.0 QC14

INSPECT SPRAY PAINT



J 09-06-16 Q



Comment: INSPECT SPRAY PAINT

X2

17.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

UMD 09/06/16

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F 09/06/16

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1 PACKAGING RESOURCE #1



SK

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

45547

q417

Sy

20.0 QC21 FINAL INSPECTION/W/O RELEASE



09/06/18 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

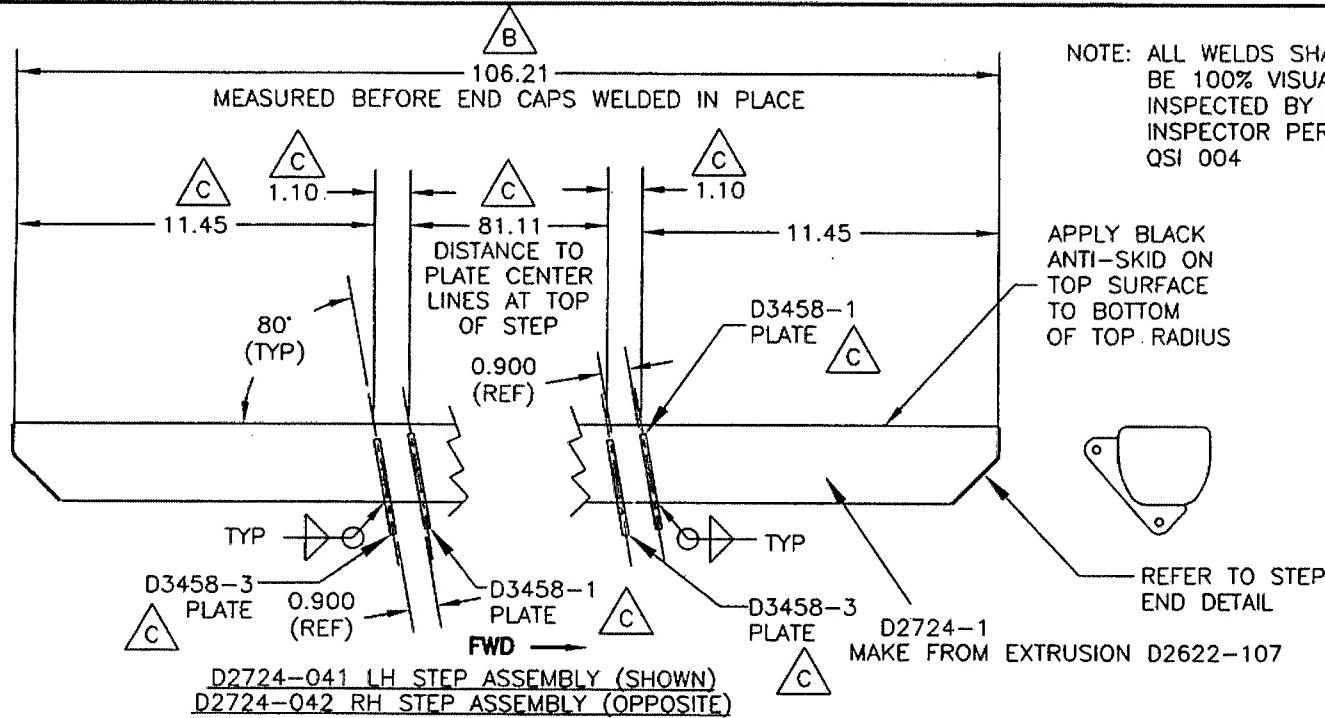
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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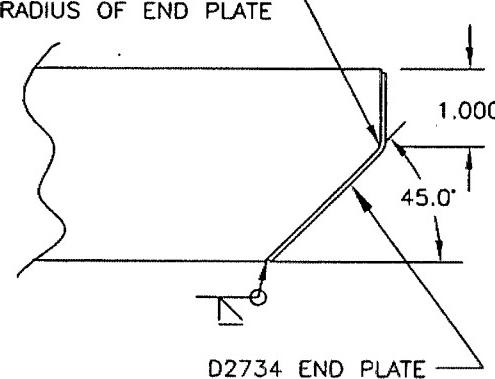
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D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

RELEASED
05.11.14

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED #	APPROVED #	DRAWING NO. D2724
DATE 05.09.19	TITLE 98.10.19	REV. C
A	NEW ISSUE	DRAWING NO. 206L/407 STEP ASSEMBLY
B	UPDATED WELD DETAIL REVISED TOLERANCES	SHEET 1 OF 1
C	RE-DESIGN, ADD D3458-1/-3	SCALE NTS

NO. 53019